

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023771**Date Inspected:** 12-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li yan hua**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

BAY#19

FCAW welding of weld is identified as 2F-042 of BK25A6-001 for BK25A. The welder is identified as 208641. ZPMC QC is identified as Mr. Li ping. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2132-ESAB.

FCAW welding of weld is identified as 3F-059 of BK25A8-001 for BK25A. The welder is identified as 062757. ZPMC QC is identified as Mr. Li ping. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2133-ESAB.

FCAW welding of weld is identified as 2F-012 of BK25A3-001 for BK25A. The welder is identified as 208632. ZPMC QC is identified as Mr. Li ping. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2132-ESAB.

FCAW welding of weld is identified as 3F-190 of BK25A57-001 for BK25A. The welder is identified as 062757. ZPMC QC is identified as Mr. Li ping. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2133-ESAB.

ZPMC QC NDT MT personnel performing MT on base metal repair locations and temporary attachment removal

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locations MT on cable bracket is identified as SA6529 is in progress.

ZPMC personnel performing SMAW welding for fit-up of bearing plate with stringer plate is in progress of bike path is identified as BK24A-001.

ZPMC personnel performing grinding of bike path fillet welds is in progress of BK23, BK25.

During in process visual inspection it is found that backing bar is not continuous in between the bearing plate CJP weld is identified as BK23A3-001-003,006 and BK3A5-001-002,009 more than that 4mm. this is marked near by the weld and informed to ZPMC QC Mr. Li ping and ABF QA Mr. Peng wen june for further repair work to go before welding. See the attached photos.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang-15--0042-2372, who represents the Office of Structural Materials for

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your project.

Inspected By: Kumar,Chadra

Quality Assurance Inspector

Reviewed By: Patel,Hiranch

QA Reviewer